

Work Order ID 72786

Friday, August 12, 2011 2:39:04 PM



ASAP

Page 1

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-08-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B11-8-15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-15

13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulos115

713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72786

Friday, August 12, 2011 2:39:04 PM



Page 2

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

(13)

8-11-08-15

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8 wlos 15

(13)

150



Powdercoat

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME: 11:40 OVEN TEMPERATURE:

FINISH TIME: 12:10

M 117338

32001

12:10

13x of m-11/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72786

Friday, August 12, 2011 2:39:04 PM



Page 3

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 8/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 6 M 11/08/15

170

Identify as per dwg & Stock Location: F-P1 0.00

Packaging

Memo

0.00

Packaging

13x 8 M 11/08/15

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/8/15 DJ

~~13 6 M 11/08/15~~

C2 11/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 2:39:10 PM

Page 1

Work Order ID: 72786



Parent Item: D3535-13



Parent Item Name: Wearshoe

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

231.4072

0.8505

10.74316

11.



1311-8-15

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

231.4072

116623

0.2

117550

9.363

117933

79.3442

118400

142.5

118400

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

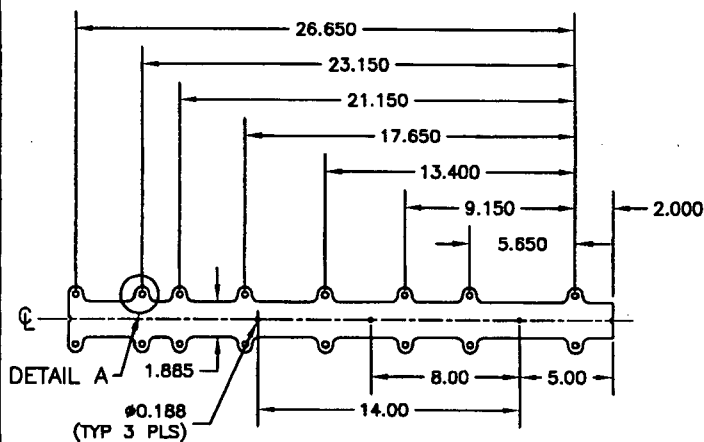
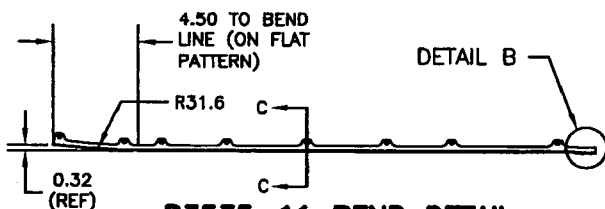
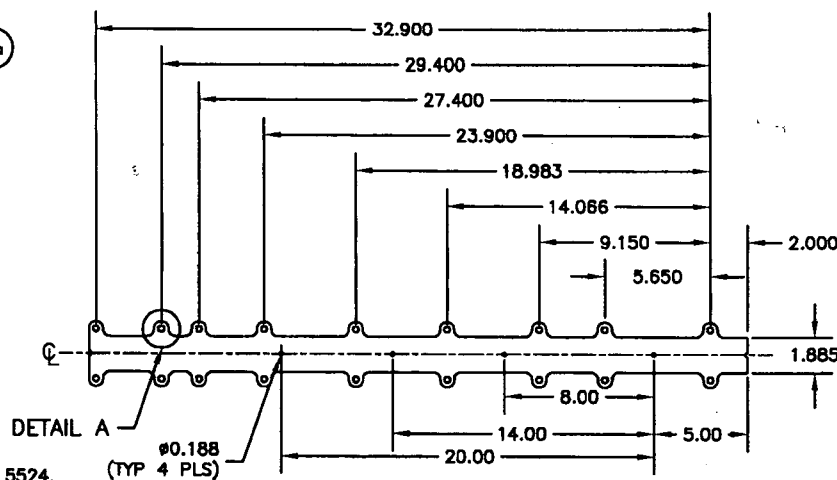
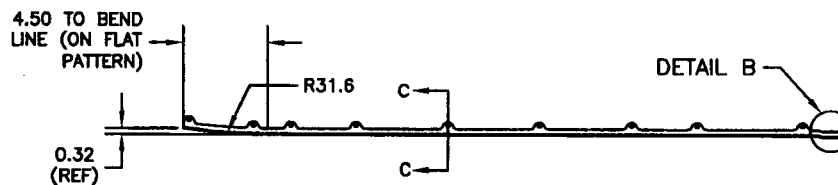
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

#72786

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	DRAWING NO.	REV. B
CB	PH	WEARSHOE	D3535	
CHECKED	APPROVED	DATE	DATE	SHEET 1 OF 7
		07.04.17	06.10.25	
A	B	NEW ISSUE	MOVE TAB OUTBOARD, ADD AMS SPEC	

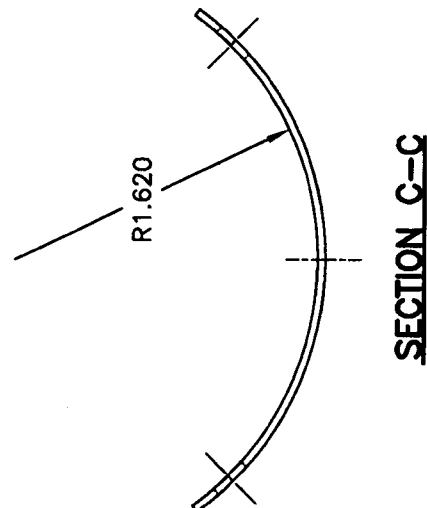
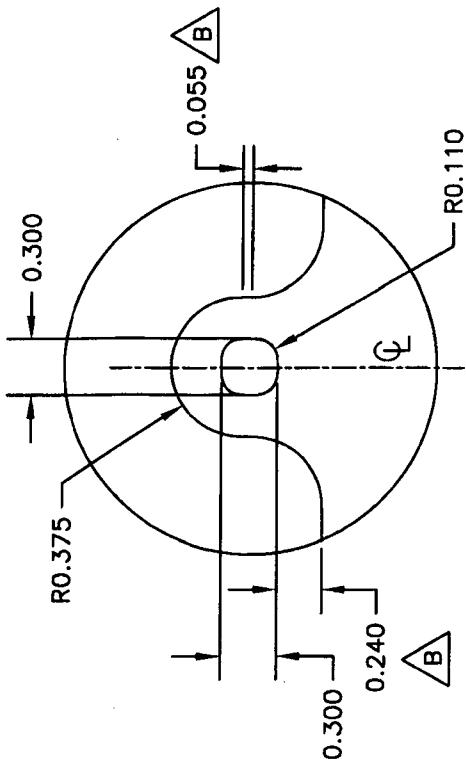
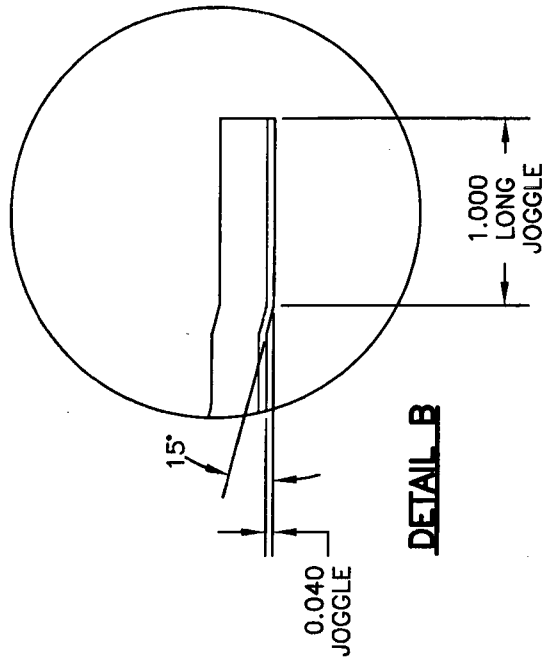


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24

#79766



Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART AEROSPACE LTD		Work Order:	72786
Description: Wearshoe		Part Number:	D3535-13
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.891	✓		V 1B02	
2.000	+/-0.010	2.000	✓		V	
5.650	+/-0.010	5.650	✓		T 1B01	
9.150	+/-0.010	9.150	✓		T	
14.066	+/-0.010	14.066	✓		T	
18.983	+/-0.010	18.983	✓		T	
23.900	+/-0.010	23.900	✓		T	
27.400	+/-0.010	27.400	✓		T	
29.400	+/-0.010	29.400	✓		T	
32.900	+/-0.010	32.900	✓		T	
Ø0.188	+0.005/-0.001	.191	✓		V	
20.00	+/-0.030	20.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
5.00	+/-0.030	5.00	✓		T	
0.300	+/-0.010	304	✓		V	
0.300	+/-0.010	301	✓		V	
0.038	+/-0.010	.036	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-8-15	Date: 11/8/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	DD